



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

POSITIVE RECALL
EFFECTIVE 12/20/17 AUTH
RELEASED DATE

D4806-1

Job Sheet 169119

Part No: D4806-1

Job Qty: 1 ea

Part Name: Clevis



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/1/17

Job Tracking No:

Due Date: 12/4/17

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP REV:A NEW ISSUE 14-01-16 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/4/17	12/4/17	0.00	0.00	Start Up Container		J.S.C. 17-02-05
105	Rework	1 pcs	12/4/17	12/4/17	0.00	0.00	Mill Conv 1		J.E.L. 17-02-05
130	Outsource	1 pcs	12/4/17	12/4/17	0.00	0.00	Outsource2		
140	Packaging	1 pcs	12/4/17	12/4/17	0.00	0.00	Packaging2		DAS
150	QC	1 pcs	12/4/17	12/4/17	0.00	0.00	QC5		
160	Packaging	1 pcs	12/4/17	12/4/17	0.00	0.00	Packaging3-2		
170	QC21-SA	1 Ea	12/4/17	12/4/17	0.00	0.00	QC21		

Part Op 130 - Outsource process - NDT per QSI038 4.1 ISSUE P/O :

C OF C IS REQUIRED

Descriptions: 140 - Receive & Inspect for Damage & Mat'l Certs

150 - QC5- Inspect part completeness to step on W/O

160 - Identify as per dwg & Stock Location: IDENTIFY AS PER QSI 044 6.7

170 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4806-1	1	12	0	0

Part Specifications

Specifications could not be found.

Plex 12/4/17 10:51 AM dart.lacelle.linda

DQA:

QA Closer

Work Order

Part

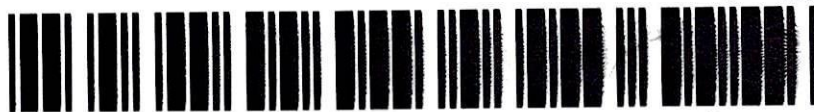
NCF

Date :

Job No: 169119
Mfg Date: 12/05/17

Outsource
D4806-1

Change No:
Operation:
Revision:
PART NO:



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Clevis

Job No: 169119
Mfg Date: 12/05/17

Start up Operation
D4806-1

Change No:
Operation:
Revision:
PART NO:



Clevis

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DATE

Work Order update only

AGAINST DEPARTMENT/PROCESS

Cross tube	☐	Water Jet	☐	Engineering	☐
Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Composite	☐	Supplier	☐		☐

MRB (QSI042) Approval

Disposition

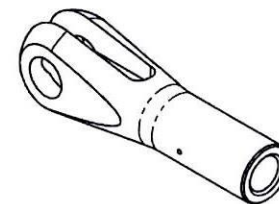
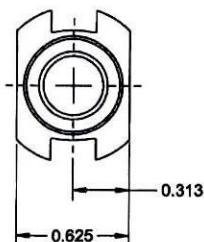
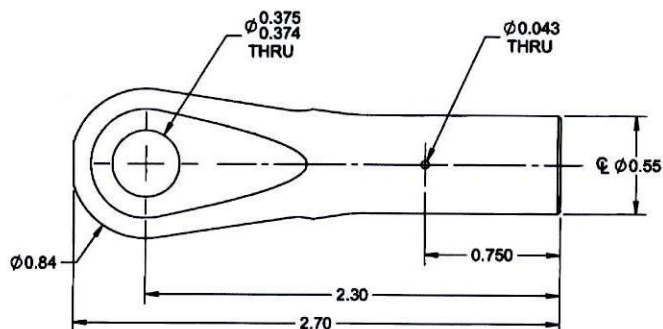
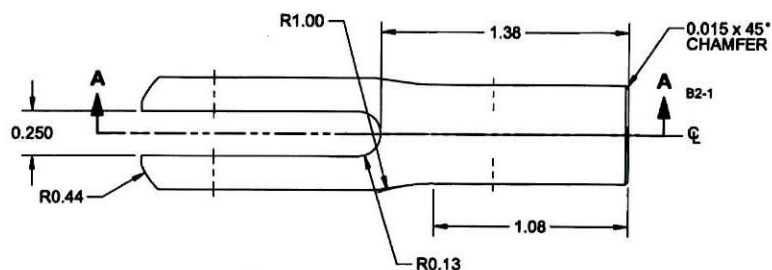
Completed By

Lead hand / Supervisor
Approval Verification

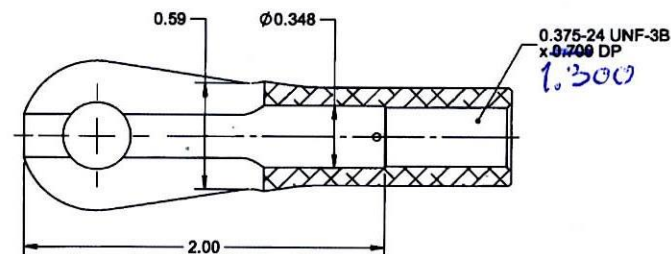
Root Cause

Environment	☐	No Re-verification	☐	Pressure/Forced	☐
Design	☐	Operator	☐	Bending	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐
Material	☐	Use for Testing	☐	Cuffs	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐
Past Expiry Date	☐	Manufacturing Process	☐		
Misidentified	☐	Past Due	☐	OTHER :	☐

8 7 6 5 4 3 2 1



DAS
22
9-89



SECTION A-A D5-1

D4806-1 CLEVIS

RELEASED
2014-06-16

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.13 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

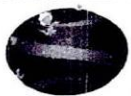
Dec

APPROVED

B	ADD CENTER DRILL TO -3 (ZN D8-2)	RF	14.04.08
A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4806 REV. B SHEET 1 OF 2 TITLE END FITTING SCALE NTS	
DRAWN	RF		
CHECKED	VS		
MFG. APPR.	JFS		
APPROVED	HS		
DE APPR.	DS	DATE 14.04.08	

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8 7 6 5 4 3 2 1

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO34370	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO038658
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:**CARRY OUT NDT ON:**

1 CLEVIS , P/N# D4806-1 , J/S# 169119

5 FWD CROSSTUBES , P/N# D119-796-141 , J/S# 168122 , 168123 , 169272 , 169272-B , 169272-C

5 AFT CROSSTUBES , P/N# D119-796-241 , J/S# 169273 , 169273-A , 169273-B , 169273-C , 169273-D

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-13 ***NO CRACK FOUND*** PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142						DEC 15 2017	 
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp 	Date: DEC 15 2017
Name: RAFIK MELIKIAN		



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038671

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO038671

PO Date: 12/18/17

Due Date: 12/18/17

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

E-MAILED
DEC 18 2017

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	169272	D119-796-141	Fwd Crosstube Installation Without Step (No Hardware) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	12/18/17	1 pcs	0 pcs	1 pcs	\$116.36/pcs	\$116.36
2	168123	D119-796-141	Fwd Crosstube Installation Without Step (No Hardware) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	12/18/17	1 pcs	0 pcs	1 pcs	\$116.36/pcs	\$116.36
3	169272-B	D119-796-141	Fwd Crosstube Installation Without Step (No Hardware) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	12/18/17	1 pcs	0 pcs	1 pcs	\$116.36/pcs	\$116.36
4	169272-C	D119-796-141	Fwd Crosstube Installation Without Step (No Hardware) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	12/18/17	1 pcs	0 pcs	1 pcs	\$116.36/pcs	\$116.36
5	168122	D119-796-141	Fwd Crosstube Installation Without Step (No Hardware) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as	Firmed	12/18/17	1 pcs	0 pcs	1 pcs	\$116.36/pcs	\$116.36



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PURCHASE ORDER PO038671

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO038671

PO Date: 12/18/17

Due Date: 12/18/17

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

E-MAILED
DEC 18 2017

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
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2	168123	D119-796-141	Fwd Crosstube Installation Without Step (No Hardware) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	12/18/17	1 pcs	0 pcs	1 pcs	\$116.36/pcs	\$116.36
3	169272-B	D119-796-141	Fwd Crosstube Installation Without Step (No Hardware) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	12/18/17	1 pcs	0 pcs	1 pcs	\$116.36/pcs	\$116.36
4	169272-C	D119-796-141	Fwd Crosstube Installation Without Step (No Hardware) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	12/18/17	1 pcs	0 pcs	1 pcs	\$116.36/pcs	\$116.36
5	168122	D119-796-141	Fwd Crosstube Installation Without Step (No Hardware) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as	Firmed	12/18/17	1 pcs	0 pcs	1 pcs	\$116.36/pcs	\$116.36



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PURCHASE ORDER PO038671

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
			per ASTM 1417 Level 2 Attach copy of NDT results to work order							
6	169273-C	D119-796-241	Aft Crosstube Installation Without Step (No Hardware) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	12/18/17	1 pcs	0 pcs	1 pcs	\$116.36/pcs	\$116.36
7	169273-D	D119-796-241	Aft Crosstube Installation Without Step (No Hardware) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	12/18/17	1 pcs	0 pcs	1 pcs	\$116.36/pcs	\$116.36
8	169273-B	D119-796-241	Aft Crosstube Installation Without Step (No Hardware) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	12/18/17	1 pcs	0 pcs	1 pcs	\$116.36/pcs	\$116.36
9	169273	D119-796-241	Aft Crosstube Installation Without Step (No Hardware) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	12/18/17	1 pcs	0 pcs	1 pcs	\$116.36/pcs	\$116.36
10	169273-A	D119-796-241	Aft Crosstube Installation Without Step (No Hardware) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	12/18/17	1 pcs	0 pcs	1 pcs	\$116.36/pcs	\$116.36
11	169119	D4806-1	Clevis Outsource process - NDT per QSI038 4.1 ISSUE P/O : _____ C OF C IS REQUIRED	Firmed	12/18/17	1 pcs	0 pcs	1 pcs	\$116.40/pcs	\$116.40
Grand Total:									\$1,280.00	

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/18/17 10:12 AM dart.baker.diane